

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009678**Date Inspected:** 02-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #1

Counter weight: - Caltrans QA inspector observed two ZPMC welders performed FCAW fillet weld process on divide plate of counter weight component #66. The fillet weld size is 8mm welded all around the plate with multiple pass. The FCAW fillet welds process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Caltrans QA inspector observed four ZPMC workers and one welder performed fit up and SMAW tack weld process on the divide plate of counter weight component #54. A numerous temporary tack welds have been welded attach to the divide plate after adjusted and secured by hand jack. Based on Caltrans QA observation, no discrepancies were noted.

Bay #2

Floor beam type 1:- Caltrans QA inspector observed two ZPMC welders performed FCAW fillet weld process on stiffeners for type-1 of floor beam #FB-3055-001 AND #FB-6501-00. The fillet weld size is 6mm and 8mm with single pass and multiple pass. The FCAW fillet welds process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Floor beam type 2:- Caltrans QA Inspector observed two ZPMC grinders in process of grinding on fillet welds of type 2 floor beams. The floor beams ID were FB-3015-002, FB-3026-001, FB-3070-001 and FB-3072-00. QA observed a numerous fillet weld areas identified by ZPMC and ABF QC that will require additional work due to

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

weld profiles exceeding AWS code limitations. The grinding process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were

Bay #6

Tower strut: - Caltrans QA Inspector observed two welders performed SMAW noncritical weld repair process on tower strut. The tower struts ID were WD1-A305-53M-2 and WD1-A305-65M-3. All of FCAW noncritical repair weld located at web to flange of tower strut which have been rejected by ZPMC UT testing. The FCAW repair process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

As notes within report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
